

Date: Wednesday, 29/04/2009 3:07:48 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : OUTER AFT SADDLE
Job Number : 47632	
Estimate Number : 11080	
P.O. Number :	Part Number : D5955
This Issue : 29/04/2009 S.O. No. :	Drawing Number : D5955 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 43249	Material :
Written By :	Due Date : 15/05/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JLD 09.04.09</u>	
Comment : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:F ecn826 06.12.06 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101013	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

D6101-013 (7075-T7351)

Size 2.50" x 10.10" X 8.25" (Grain along 10.10")

Batch: 41963X86 38696X1

J.L 09/05/04

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5955, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

J.L 09/05/04

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

J.L 09/05/04

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.P 09/05/04

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

U.M.D./R

09/05/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D5955 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: P Date: 09/05/08

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47632</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/05/04</u>	<u>2.0</u>	<u>2 parts have a .080 chamfer on front of island only instead of .045</u>	<u>CP</u> <u>09.05.04</u> <u>pc</u> <u>QSI 042</u>	<u>Acceptable</u>	<u>JL</u> <u>09/05/04</u>	<u>S</u> <u>09/05/04</u>	<u>CP</u> <u>09.05.04</u> <u>pc</u> <u>QSI 042</u>	<u>S</u> <u>09/05/04</u>

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:07:49 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER AFT SADDLE

Job Number: 47632

Part Number: D5955

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m 109996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(7)

START TIME:

7:15

OVEN TEMPERATURE:

320°

FINISH TIME:

7:45

FL 09/05/06

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-06 (X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST- 430

SS 09/05/07 (X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/07 (X)

Job Completion



MF
09-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	47632
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955		Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		.319	.319	.319	.319		
L	0.495	0.505		.499	.500	.499	.499		
M	0.490	0.510		.498	.500	.499	.500		
N	1.865	1.885		1.884	1.882	1.882	1.881		
O	7.990	8.010		8.000	8.000	8.000	7.999		
P	2.240	2.260		2.253	2.250	2.249	2.249		
Q	0.307	0.312		.310	.311	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.505	.504	.501	.502		
T	1.625	1.645		1.635	1.637	1.638	1.638		
U	2.000	2.020		2.007	2.008	2.008	2.008		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.L.
Date:	09/05/04

Audited by:	SP
Date:	09/05/04

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

DART AEROSPACE LTD		Work Order:	07632
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955		Rev: B	Page 1 of 1

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O	7.990	8.010		7.999	7.999	7.999			
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Q	0.307	0.312		.310	.310	.310			
R	0.760	0.765		.760	.760	.760			
S	0.490	0.510		.500	.500	.504			
T	1.625	1.645		1.639	1.638	1.639			
U	2.000	2.020		2.007	2.008	2.009			
V	0.023	0.043		.033	.033	.033			
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

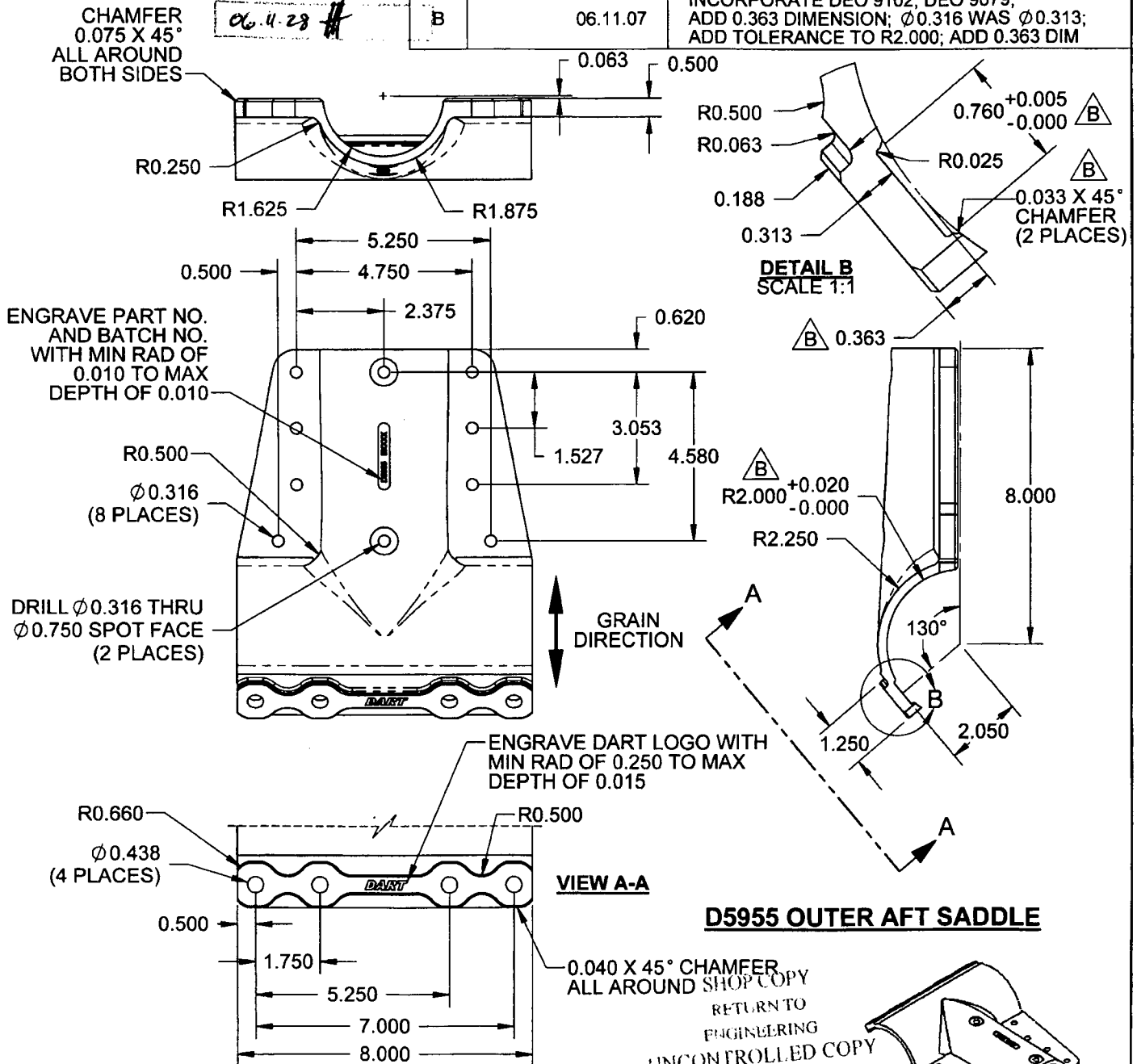
Measured by:	IL
Date:	09/05/04

Audited by:	88
Date:	09/05/04

Rev	Date	Change	Revised by	Approved
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E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5955	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER AFT SADDLE SCALE 1:4		
REV	DATE	DESCRIPTION	
A	97.05.06	NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

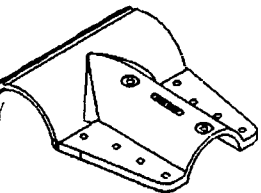
**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005.4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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**ISOMETRIC VIEW**
SCALE 1:8